

Date: Thursday, 07/12/2006 6:55:36 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CLAMP
Job Number : 29769	
Estimate Number : 10584	
P.O. Number : N/A	Part Number : D1048
This Issue : 07/12/2006 S.O. No. : N/A	Drawing Number : D1048 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 29769	Material : N/A
Written By : <u>W</u>	Due Date : 15/01/2007 Qty: 50 Um: Each
Checked & Approved By : <u>W</u>	
Comment : Est: B 02.02.22 Re-format NG Est Rev:C Now on Waterjet 06-12-06 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S16GA	304/316 .063 Sheet
-----	-----------	--------------------



Comment: Qty.: 0.0116 sf(s)/Unit Total: 0.5775 sf(s)

304/316 .063 Sheet

Batch: M101873

ml 07/01/05

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D1048

Dwg Rev: A

Prog Rev: A

ml 07 01 09

(50)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 07 01 09

(50)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

11/07/01/09 (50)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if required. Break all sharp corners .010 / .020 as per dwg.

SB 11-01-07 (50)

Date: Thursday, 07/12/2006 6:55:36 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 29769

Part Number: D1048

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form as per dwg D2010 using DT8053

FF 07-01-26

PTO

49

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/01/29 (49)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M-B/a.m

07/01/31

M100700

(49x)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PC 7/02/06 (49)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PC 7/02/06 (49)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/02/07 (49)

Job Completion



U 07.02.07

Date: Tuesday, 12/5/2006 8:14:16 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CLAMP
Job Number : 29769	
Estimate Number : 10584	
P.O. Number :	Part Number : D1048
This Issue : 12/5/2006 S.O. No. :	Drawing Number : D1048 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : A
Previous Run : 27091	Material :
Written By :	Due Date : 1/15/2007 Qty: 50 Um: Each
Checked & Approved By : <i>06 12 05</i>	
Comment : Est: B 02.02.22 Re-format NG	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: _____

Stamp and deburr per dwg D1048

Material: Stainless steel 7304#2B Supply release not for Material.

*OLD SF
m20151614
Water Jet*

2.0

D1048F

Clamp



Comment: Qty.: 1.0000 U(s)/Unit Total : 50.0000 U(s)
CLAMP

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if required. Break all sharp corners .010 / .020 as per dwg.

2-Form as per dwg D2010 using DT8053

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: D Date: 07/02/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/01/09	2.0	DDXF was wrong holes were 1.38 center to center, but were supposed to be 1.705	<i>[Signature]</i> 05/04/09	Fix Program, Destroy Pieces and re-cut	<i>[Signature]</i> 07/01/09	<i>[Signature]</i> 07/01/09	<i>[Signature]</i> 05/04/09	<i>[Signature]</i> 07/01/09
07/01/26	6.0	Bracket off center	<i>[Signature]</i> 05/04/09	Scrap + Destroy No replace.	<i>[Signature]</i> 07/01/26	<i>[Signature]</i> 07/01/26	<i>[Signature]</i> 05/04/09	<i>[Signature]</i> 07/01/26

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 8:14:16 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 29769

Part Number: D1048

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
97/09/02 REC

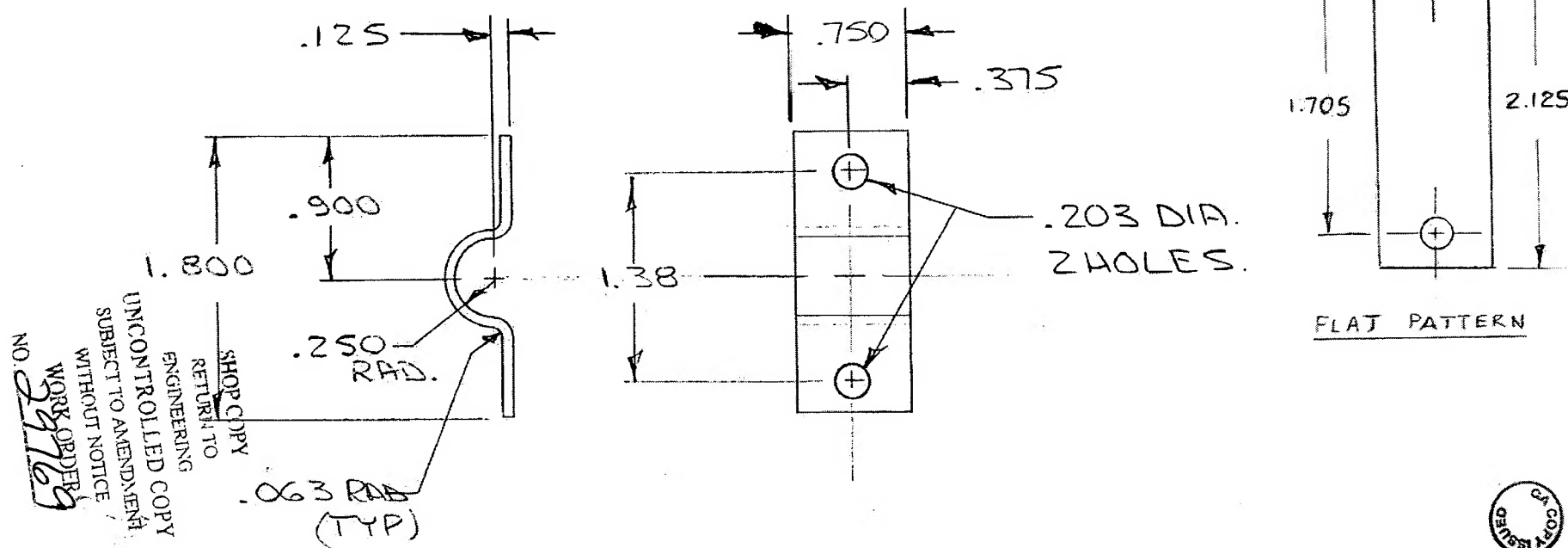
NOTES:

1) MATERIAL

STAINLESS STEEL
T304#2B .062 THICK

2) FINISH = POWDER COAT BLACK SANDTEX (REF. 4.3.5.7)
PER DART QSI 005 4.3

3) BREAK ALL SHARP EDGES 0.010 TO 0.020



NO. 29769
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY



A		REVISION	RIVET CODE SHALL BE PER HAS 523		PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR
RF		DRAWN	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		CONTRACT NO.		DART AERO ACCESSORIES INC. VANCOUVER CANADA		
		APPROVED	BASIC CODE		DRAWN		DATE		
			D-DIMPLE DIGIT NO OF SHEETS C-COUNTERSINK		DESIGN		1/97		
		DESCRIPTION OF CHANGE	BASIC CODES		STRESS		TITLE		
			8J-M520470AD 8B-M520470AD		CHECKED		CLAMP		
			REPORT ALL DISCREPANCIES - DO NOT SCALE		CUT		CODE		
							D 1048		
							SCALE 1:1 SHT 1 OF 1		

D 1048

A

DART AEROSPACE LTD	Work Order:	29769
Description: Clamp	Part Number:	D1048
Inspection Dwg: D1048	Rev: A	Page 1 of 1

X	First Article	X	Prototype
----------	----------------------	----------	------------------